ASAP Ship 7/02 Monday

Work Order ID 66041

Thursday, February 03, 2011 7:25:36 AM

Item ID: D3670-4-200 **Accept** **Setup Start**

Revision ID:

Item Name: SPACER **Stop**

Start Date: 2/3/2011 **Start Qty:** 40.00 **Cust Item ID:**

Required Date: 2/10/2011 **Req'd Qty:** 40.00 **Customer:**

Reference: 11.02.03.

Run Start

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3670	Rev A

100
Hardinge
Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL — 0.00

Memo — 0.00

1-TURN AS PER ~~FOLIO~~ FA711& DWG D3670i FOLIO REV: A
DWG REV: A
2-DEBURR AS REQUIRED

11.2.4 40 ∅

110
QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB — 0.00

Memo — 0.00

11.2.4 40 ∅

120
QC
Quality Control

QC8- Inspect parts - second check — 0.00

Memo — 0.00

J.F.S 11/02/04 40 ∅

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 66041

Thursday, February 03, 2011 7:25:36 AM

Item ID: D3670-4-200

Accept

Setup **Start**

Revision ID:

Item Name: SPACER

Stop

Start Date: 2/3/2011 **Start Qty:** 40.00

Required Date: 2/10/2011 **Req'd Qty:** 40.00

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Run **Start**

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging	Identify as per dwg & Stock Location LG	0.00	cont			11/2/7SD	(400)		
Packaging	**Memo** ***STOCK IN SKIDTUBE CELL***	0.00							
140 QC	QC21- Final Inspection - Work Order Release	0.00							11/02/08
Quality Control	**Memo**	0.00							MF 11-02-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, February 03, 2011 7:25:33 AM

Work Order ID: 66041

Parent Item: D3670-4-200

Parent Item Name: SPACER

Start Date: 2/3/2011 **Required Date:** 2/10/2011

Start Qty: 40.00 **Required Qty:** 40.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.058 ALUM TUBE .3125 x .058w		Purchased	No				f	0.0001		14.40720			

Location	Loc Qty	Loc Code
MAT	8.42105E-05	
14559	8.4211E-05	

116793

14.33

11.2.4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: __________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: __________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	66041
Description: Spacer	Part Number:	D3670-4200
Inspection Dwg: D3670 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

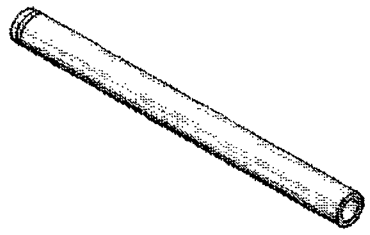
[X] First Article [ ] Prototype

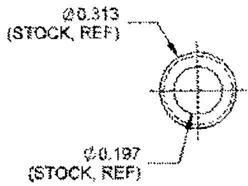
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.313	+/-0.010	.313	✓		RQ-07	
Ø0.197	+/-0.010	.198	✓			
4.200	+/-0.010	4.202	✓			
0.060	+/-0.010	.065	✓			
R0.03	+/-0.030	R.030	✓			
0.015	+/-0.010	.014	✓			

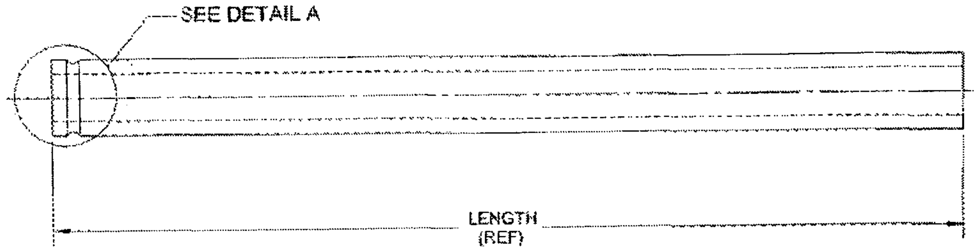
Measured by:	[signature]	Audited by:	J.F.S.	Prototype Approval:	N/A
Date:	11.2.4	Date:	11/02/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD [signature]	[signature]

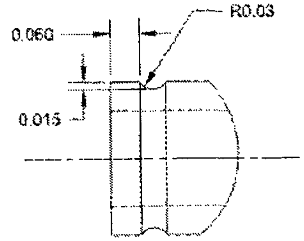
SPECIFICATION CONTROL DRAWING







w/o 6604



DETAIL A
(SCALE 4 : 1)

SPECIFICATION: D3670-XXXX SPACER
LENGTH

WHERE XXXX IS LENGTH IN INCHES
EG: 3.750" LONG SPACER: D3670-3750

RELEASED 07.11.05

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4 1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: N/A

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	DC	07.10.19

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3670 — REV. A — SHEET 1 OF 1
MFG. APPR.		
APPROVED		TITLE SPACER — SCALE 2:1
DE APPR.		
DATE	07.10.19	